

Date: Monday, 5/14/2007 2:00:54 PM
 User: Chantal Lavoie

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: BRACKET		
Job Number	: 32345					
Estimate Number	: 12806					
P.O. Number	:			Part Number	: D35702	
This Issue	: 5/14/2007		S.O. No.	: D3570 REV.B		
Prsht Rev.	: NC			Project Number	: N/A	
First Issue	: //		Type	: SMALL /MED FAB		
Previous Run	: 31867			Drawing Revision	: B	
Written By	:			Material	:	
Checked & Approved By	:			Due Date	: 5/15/2007	
Comment	: Est Rev:A New Issue 07-03.26 ec			Qty:	20	Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :		
1.0	M6061T6S125	6061-T6 .125 Sheet		
		Comment: Qty.: 0.0746 sf(s)/Unit Total : 1.4910 sf(s) 6061-T6 .125 Sheet Batch: <u>M103156</u>		<i>SAD 07/05/14</i>
		Grain must be Along 4.63"**		
2.0	WATER JET	FLOW WATER JET		
		Comment: FLOW WATER JET 1-Cut as per Dwg D3570 Dwg Rev: <u>3</u> Prog Rev: <u>3</u>		<i>SAD 07/05/14</i>
		2-Deburr if necessary		<i>MF 07-05-22</i>
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE		
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE		<i>SAD 07/05/14</i>
4.0	QC8	SECOND CHECK		
		Comment: SECOND CHECK		<i>SC 07-05-03</i>
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1		
		Comment: SMALL & MEDIUM FAB RESOURCE 1.		<i>PTO 07-08-03</i>
		Form as per Dwg D3570		<i>FF 07-08-03</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3570-2 PAR #: N/A Fault Category: Prod-Sm.Fab NCR: Yes No DQA: AA Date: 07.08.13
 QA: N/C Closed: AA Date 07.08.21

NCR: <u>32345</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/05/14	2.0	Scrap 3 part bad to change offset and Speed in program.	<u>Q5104</u>	Scrap-destroy, replace B# <u>M103156</u>	SAD 07/05/14	<u>Q5104</u>	<u>Q5104</u>	<u>Q5104</u>
07/05/14	2.0	Scrap 2 part program malfunction	<u>Q5104/2</u>	Scrap-destroy, replace B# <u>M103156</u>	SAD 07/05/14	<u>Q5104</u>	<u>Q5104</u>	<u>Q5104</u>
07/06/14	5.0	apare inspection found 7 parts with 0.365 under tol. Dim. varying from 0.352" to 0.328"	<u>AA</u>	ACCEPTABLE Deviation	AA 07.06.07	<u>Q5104</u>	<u>Q5104</u>	<u>Q5104</u>

NOTE: Date & initial all entries marked and cat shot.

Date: Monday, 5/14/2007 2:00:55 PM
User: Chantal Lavoie

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

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Part Number: D35702

Job Number:



Seq. #:	Machine Or Operation:	Description :
6.0	QC5	INSPECT WORK TO CURRENT STEP
		<i>Ex 07/08/07 XIS</i>
Comment: INSPECT WORK TO CURRENT STEP		
7.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
		<i>M 07 08 10</i>
Comment: HAND FINISHING RESOURCE #1		
	Chemical Conversion Coat as per QSI 005 4.1	
8.0	POWDER COATING	POWDER COATING
		<i>M 104846 KX</i>
Comment: POWDER COATING		
	Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3	
9.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
		<i>ED 07/08/13 18</i>
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION		
10.0	PACKAGING 1	PACKAGING RESOURCE #1
		<i>ED 07/08/13 19</i>
Comment: PACKAGING RESOURCE #1		
	Identify with P/N and B/N as per Dwg using a permanent fine point marker, then Stock	
Location:		
11.0	QC21	FINAL INSPECTION/W/O RELEASE
		<i>A 07.08.13</i>
Comment: FINAL INSPECTION/W/O RELEASE		

Job Completion



C 07/08/13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

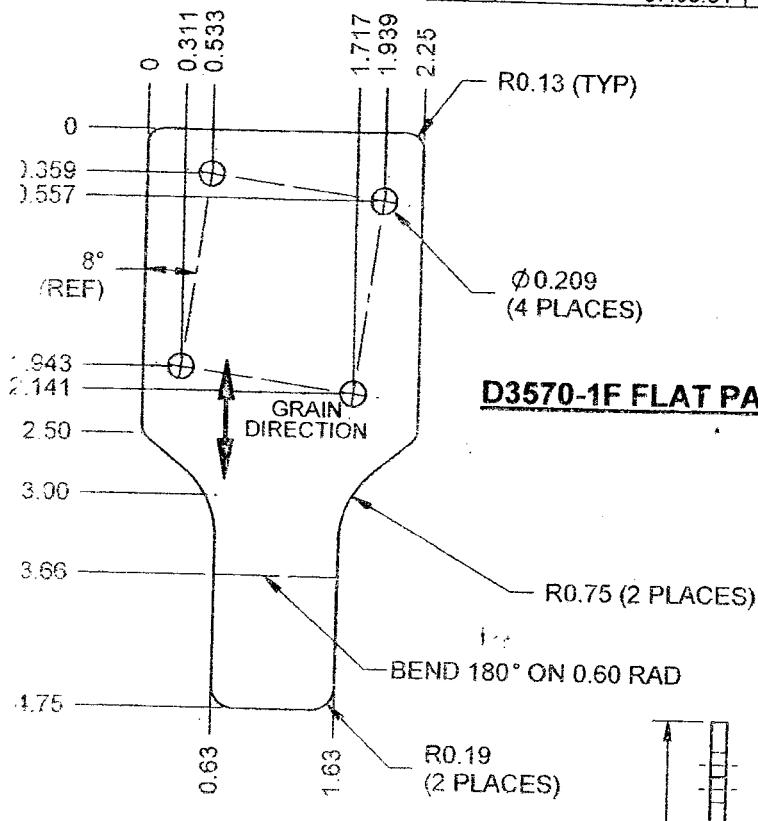
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGNER <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>B</i>	APPROVED <i>AT</i>	DRAWING NO. D3570	REV. C SHEET 1 OF 1	
DATE 07.06.01	TITLE BRACKET		SCALE 2:3	
REV	DATE	DESCRIPTION		
A	07.02.07	NEW ISSUE		
B	07.04.16	CHANGE BEND RAD TO 0.60 FROM 0.50		
C	07.06.01	UPDATE DIMS FOR CLARITY		



D3570-1F FLAT PATTERN

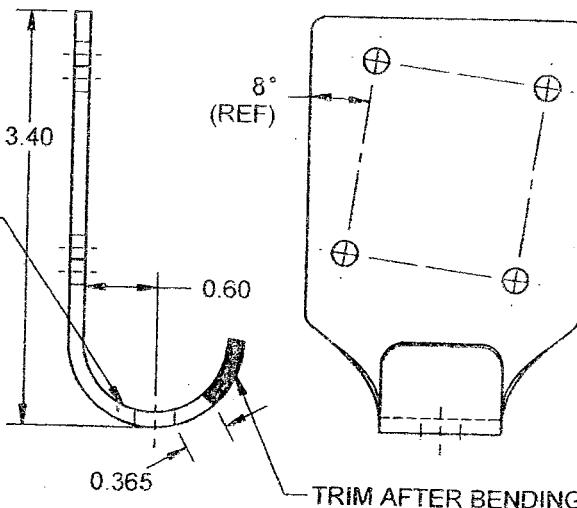
RELEASED

07-06-04 off

103234

**D3570-1 BRACKET SHOWN
(MAKE FROM D3570-1E)**

D3570-2 BRACKET OPPOSITE
(MAKE FROM D3570-1F)



NOTES

1) MATER AL: 6061-T6 (OR T62) ALUMINUM 0.125" THICK PER QQ-A-250/11 OR AMS 4025/4027
(REF DART SPEC M6061T6S.125)

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3

3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

4) IDENTIFY WITH DART P/N "D3570-1/-2" USING FINE POINT PERMANENT INK MARKER

5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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DART AEROSPACE LTD		Work Order: 32345
Description: Bearpaw BRACKET		Part Number: D35702
Inspection Dwg: D35702 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A 0.359	+/- 0.010	0.364	✓		Vern	
B 0.557	+/- 0.010	0.561	✓		Vern	
C Ø.943	+/- 0.010	1.943	✓		Vern	
D 2.141	+/- 0.010	2.143	✓		Vern	
E 2.50	+/- 0.030	2.51	✓		height gauge	
F 4.75	+/- 0.030	4.76	✓		Vern	
G 0.63	+/- 0.030	0.64	✓		height gauge	
H 1.63	+/- 0.030	1.65	✓		height gauge	
I 0.311	+/- 0.010	0.316	✓		Vern	
J 0.533	+/- 0.010	0.536	✓		Vern	
K 1.717	+/- 0.010	1.720	✓		Vern	
L 1.939	+/- 0.010	1.944	✓		Vern	
M 2.25	+/- 0.030	2.26	✓		Vern	
N Ø 0.209	+ 0.005 - 0.001	Ø 0.209	✓		Vern	
O 0.125	+/- 0.010	0.120	✓		Vern	
P						
Q						
R						
S						
T						
U						
V						
W						
X						
Y						

Measured by: BAD	Audited by: E	Prototype Approval: <input checked="" type="checkbox"/>
Date: 07/05/14	Date: 07-05-14	Date: 07-05-14

Rev	Date	Change	Revised by	Approved
A	04.01.09	New Issue	KJ/RF	